

**Work Order ID 115196**

Monday, March 17, 2014 2:50:18 PM

**\*115196\***

Page 1

**PRELIMINARY ISSUE**

Item ID: D3984

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 3/17/14

Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 3/17/14

Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-03-19

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3984

A-PRELIM 

100

0.00

**\*100\***

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 23480

Rubber extrusion

Possible Supplie: Accurate rubber

P/N: 110750006

Material release note required

\*\*\*EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE  
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH  
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,  
OR DENTS.\*\*\*

\*\*\*MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE\*\*\*

110

0.00

**\*110\***

Packaging

Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

Memo

Ensure material release note is attached

0.00

QZ 14/03/24 100P410/c (100)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 115196**

Monday, March 17, 2014 2:50:19 PM

**\*115196\***

Page 2

Item ID: D3984

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 3/17/14 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

100X **DAS**  
28  
9-89 MAY 06 2023

130

Identify as per dwg & Stock Location: 51413

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

100X **DAS**  
28  
9-89 MAY 08 2014

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MLJ 14-05-08  
14-05-07  
**POSITIVE RECALL**  
EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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### FAULT CATEGORY

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# Picklist Print

Monday, March 17, 2014 2:50:18 PM

Page 1

Work Order ID: 115196

**\*115196\***

Parent Item: D3984

**\*D3984\***

Parent Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP rev A 09.11.12 new issue EC verified :DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
110750006 <b>*110750006*</b> Rubber Extrusion		Purchased		No			Each <i>R</i>	0.0000		100		<i>144/06</i>	<i>(100)</i>

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

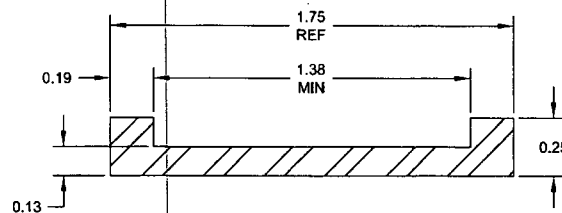
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Handling/Pre									
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Training									
Transport									
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# SPECIFICATION CONTROL DRAWING



## D3984-XXX

PART NUMBERING: D3984-035

BASIC PART LENGTH IN TENTHS OF AN INCH

EXAMPLE: D3984-035 = PART 3.5 INCHES LONG  
EXAMPLE: D3984-100 = PART 10.0 INCHES LONG

115196 IP  
14-03-19

RELEASED  
2009-11-11  
MP

### NOTES:

- 1) MATERIAL: NEOPRENE BLACK 50 DUROMETER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) PREFERRED SUPPLIER: ACCURATE RUBBER (ACR GROUP), RICHMOND, B.C., CANADA  
PART NUMBER 110750006

REV.	NEW ISSUE	DESCRIPTION	AJS	09.11.06
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3984	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		RUBBER EXTRUSION, X-TUBE	NTS	
DATE	09.11.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO23480

Purchase Order Date 3/24/2014

PO Print Date 3/24/2014

Page Number 1 of 2

Order From :

VC-ACR001

ACR GROUP INC.  
12771 - NO. 5 ROAD  
RICHMOND, BC V7A 4E9  
CA

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

294/03/29

Contact Name

Vendor Phone 604 274 9955

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Vendor Part Number						
	Line Comments		Promise Date				
	Delivery Comments						
1	110750006	Rubber Extrusion	4/4/2014 Yes 4/4/2014		100.00 f	\$5.50	\$550.00
	AS PER DWG D3984 REV. A B115196						
						Line Total:	\$550.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/4/2014 No 4/4/2014		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A015 shelf life controlled material 60% A016 personnel qualification A017 raw material identification A026 certification of material conformance A041 Quality management system A043 retention of quality documents						

Note:

3/24/2014





www.acrgroup.ca

12771 No. 5 Road  
Richmond, B.C.  
Canada V7A 4E9

Tel: 604-274-9955  
Fax: 604-274-1013  
Toll Free: 1-888-478-2237

# PACKING SLIP

CUSTOMER COPY

PACKING SLIP: 00150080

CUSTOMER NO. 10750

PST#

S  
O  
L  
D  
  
T  
O

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7  
Canada

S  
H  
I  
P  
  
T  
O

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7  
Canada

DATE		SHIP VIA		TERMS	
05/02/14		DAY & ROSS		ACR GROUP INC. NET 30 DAYS	
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON	
P023480		03/24/14		00150080 ROB	
QUANTITY		ITEM NUMBER		DESCRIPTION	
ORDERED	SHIPPED	B.O.		UNIT	AMOUNT
100	100		110750006	FT	
			EXTRUSION DIE # 1234 50+/-5 "A" NEO DWG# D3984		
			1 CTW 20#		
			DAS 27 9-89 M/S/6		
			SUBTOTAL HST		
			TOTAL AMOUNT		
FREIGHT: Collect					

Quality Rubber Products To Your Requirements  
Specialists in Bonding Natural and Synthetic Rubber To Metal  
Molded and Extruded Rubber Products, Cast Polyurethane Specialties



12771 No. 5 Road  
Richmond, B.C.  
Canada V7A 4E9  
Tel : (604) 274-9955  
Fax : (604) 274-1013

## CERTIFICATE OF COMPLIANCE

Date : 2014-05-01

Customer : Dart Aerospace LTD

Customer P.O. # : PO23480

ACR W.O. # : 15008001

Item # : 110750006

Item Description: Exrusion 50 +/- 5 "A" NEO

ACR Compound : A - 106

Date Shipped: May 1, 2014

*This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.*

**Michael Reilander**  
(ACR GROUP INC. REPRESENTATIVE)